



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 171665



Part No: D350-591-312

Job Qty: ~~10 ea~~ *9 units*

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/14/18	0.00	0.00	Start Up Large Fab-4		<i>SL 2/23/18</i>
110	Large Fab	10 pcs		2/15/18	0.00	10.00	Large Fab 2		<i>SL 2/23/18</i>
120	QC	10 pcs		2/15/18	0.00	0.00	QC9		<i>PD 18-2-23</i>
130	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>PD 18-2-23</i>
140	HandFinish	10 pcs		2/15/18	0.00	1.87	HandFinish1		<i>18-02-23</i>
150	QC	10 pcs		2/15/18	0.00	0.00	QC7-2		<i>PD 18-2-26</i>
180	Large Fab	10 pcs		2/15/18	0.00	10.00	Large Fab 2		<i>SL</i>
190	QC	10 pcs		2/15/18	0.00	0.00	QC10		<i>EB</i>
200	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>EB</i>
210	HandFinish	10 pcs		2/15/18	0.00	1.87	HandFinish1		<i>18-03-02</i>
220	Powdercoat	10 pcs		2/15/18	0.00	2.98	Powdercoat1		<i>18-3-07</i>
230	HandFinish	10 pcs		2/16/18	0.00	1.87	HandFinish3		<i>BEBAS-3-07</i>
240	QC	10 pcs		2/16/18	0.00	0.00	QC3		<i>11 MAR 12 2018</i>
250	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging1-3		<i>9-89</i>
260	QC	10 pcs		2/16/18	0.00	0.00	QC4		<i>7-10</i>
265	DC	10 pcs		2/16/18	0.00	0.00	DC		<i>10-10</i>
270	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging3-1		<i>10-10</i>
280	QC21-FG	10 Ea		2/16/18	0.00	0.00	QC21		<i>21 MAR 13 2018</i>

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod *M138673* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M138673* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: *10:15am* OVEN TEMPERATURE: *320F* FINISH TIME: *10:45am*

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

501380

wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	

WORK ORDER NON-CONFORMANCE / UPDATE

QA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	
D3067-1	End Plate	10 Ea (1 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	91	0
	D3219-1	20	98	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	2	0
	D3066-1	20	90	0
	D3067-1	10	91	0
250-Packaging	MS20600-AD4W4	160	1,321	0
	AN3-35A	20	164	0
	AN4-13A	80	618	0
	AN5-36A	20	90	0
	D2230-3	40	133	0
	D2618	20	36	0
	D2856-400	12	95	0
	D3235-1	20	6	0
	D3278-041	10	21	0
	MS21042L3	20	3,805	0
	MS21042L4	80	1,991	0
	MS21042L5	20	501	0
	NAS1149D0363J	40	3,717	0
	NAS1149D0463J	160	3,420	0
	NAS1149D0563J	40	1,501	0

Part Specifications

Specifications could not be found.

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

MAR 12 2018



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

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Container No: S043820
Part: D350-591-312
Job No: 171665
Serial No/Batch: S043820
Revision: D3272
Inspector:

Date: 02/20/18

FAULT CATEGORY				
Fault Category	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001390	S047804	AN3-35A	Bolt	s017089	ST348	20 18
001390	S047801	AN4-13A	Bolt	s027722	ST344	80 72
001390	S047800	AN5-36A	Bolt	s014157	ST336	20 18
001390	S049426	D2230-3	Mounting Lug	s049159	ST521	20 12
001390	S049435	D3235-1	Mounting Lug	s049171	ST522	20 18
001390	S049425	D3278-041	Support Assembly	s048828	ST522	10 9
001390	S047778	MS21042L3	Nut	S038764	ST303	20 18
001390	S047777	MS21042L4	Nut	S045901	ST303	80 72
001390	S047776	MS21042L5	Nut	S016880	ST303	20 18
001390	S047743	NAS1149D0363J	Washer	S015269	ST263	40 36
001390	S047742	NAS1149D0463J	Washer	S027736	ST263	160 144
001390	S047735	NAS1149D0563J	Washer	S025743	ST263	40 36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2230-3 x 24 S038157

D2618 2x (x8) S043411

D2856-400-720 S037326 x 18

Plex 3/8/18 3:07 PM dart.quirion.sonia

REF. ONLY

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hell-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hell-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hell-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hell-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hell-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hell-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]